


Date: Thursday, 8/24/2006 10:36:52 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: INITIAL PROTOTYPE TEMPLATE
Job Number	: 00053A	Part Number	: INITIAL PROTOTYPE D3524-041
Estimate Number	: 10068	Drawing Number	: N/A
P.O. Number	: N/A	Project Number	: P604-654
This Issue	: 8/24/2006	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 5/15/2006
Previous Run	: 00052A	Qty:	2 Um: Each
Written By	: 		
Checked & Approved By	:		
Comment	: Project #: _____		
	: Description: _____		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #	Machine Or Operation:	Description:
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1.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs


MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

- F-M6061 T6 B250 x 0400 $\frac{1}{4}$ " x 6.00" ^(0.375) bar batch: M100351

- Cut as per Dwg D3524 (D3524-3 detail) SAD 06.08.26 ②

- Mill as per Dwg D3524  06.08.29

- QC2  06.08.29

- QC8

- Acid etch & Abalone


- Pick & Assemble

- 4 MS21075 L06N anchor Nut batch: M101807

- ~~8 MS20426 A03-5~~ ~~Pin~~

- ~~8 MS20426 A03-4~~ ~~Pin~~

- QC5

batch: ~~M11179~~
 batch: ~~M11179~~ M15786
 06.08.18

2.0	PG	PURCHASING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00053A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3.0

PACKAGING 1

PACKAGING RESOURCE #1



not
required

Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

for testing
CB

4.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

ENGINEERING RESOURCE #1

Approval of project manager CB 07.03.08

5.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

②
P057103/09

Job Completion



PRELIMINARY ISSUE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
SHEET 2 OF 2

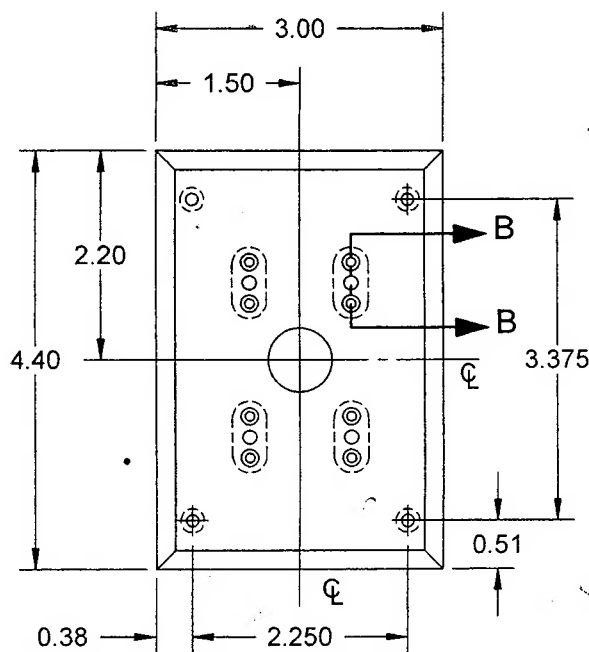
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
DATE	06.05.02	TITLE
		UPPER AND LOWER PLATE
		SCALE
		1:2

3.228
2.792

1.608
1.722

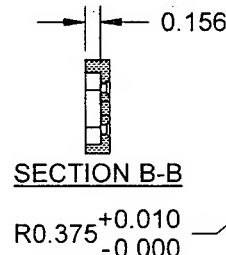
UNDER REVIEW
06.08.15 CB
prototype

INSTALL
MS21075-06 ANCHOR NUT (1)
MS20426AD3-5 RIVETS C'SINK OTHER SIDE (2)
(4 PLACES)

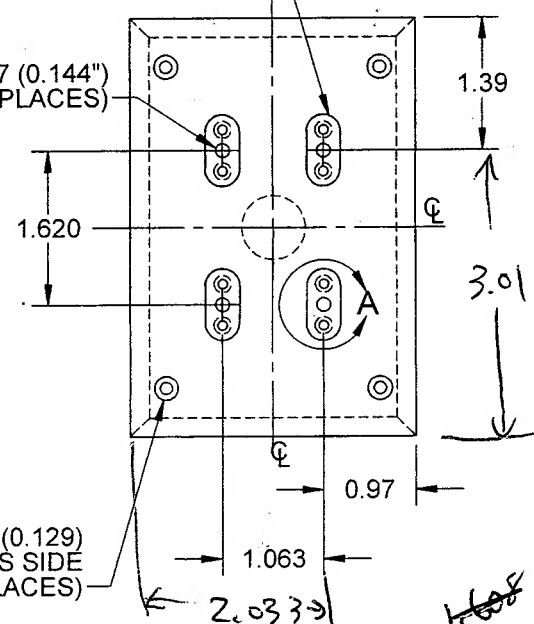


D3524-3 UPPER PLATE

CHAMFER
0.20 x 45°
TYP ALL SIDES



DRILL #27 (0.144")
(4 PLACES)

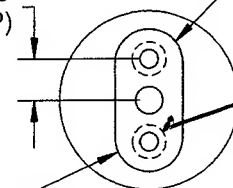


DRILL #30 (0.129)
C'SINK Ø0.250 X 100° THIS SIDE
(4 PLACES)

0.218
(TYP)

MILL SLOT
0.156 DEEP

DETAIL A
SCALE 1:1



PARTS LIST

QTY	P/N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-5	RIVET

NOTES:

- 1) MATERIAL: 6061-T651 ALUMINUM BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC. M606.1T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART SYMMETRICAL ABOUT ϕ

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KAISER ALUMINUM
1111 S 74 E Ave
Pulsa, OK 74145

COPPER & BRASS SALES
CUSTOMER PICK-UP
5755 GRANT AVE
CLEVELAND, OH 44105

PAGE 1

COPPER & BRASS SALES

SOUTHFIELD

MI 48086 CI7994

01/29/06

SOLD TO

PURCHASE ORDER

DATE PRINTED

SOLD TO

PURCHASE ORDER

DATE PRINTED

019842-4

250 X 6.000 RECT BAR

CUSTOMER PART NUMBER

DESCRIPTION

803502-001

385

111

RELEASE-ITEM

LOT

6061-T6511

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
385	111 . 0001 0001	48.7	45.6	12.7		N/A	N/A
385	111 0001 0002	48.9	45.9	12.6		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15	
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00	

APPLICABLE REQUIREMENTS:

ASTM-B221-02-STENCILED
ASME-SB221 1998 SECT II
AMS-QQ-A-200/8
UNS#96061

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

SOLD TO:




002409

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON
CANADA K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON
CANADA K6A 1K7

~~MA100351~~

ORDER NO.		DATE	SHIP VIA	TERMS	F.O.B.			
PO00001760		08/09/06	FEDX INTL ECON COLL	NET 45	FOB-MIAMI			
ITEM NO.	QUANTITY ORDERED	PART NUMBER AND DESCRIPTION		PRICE	UNIT	BACK ORDER	SHIPPED	AMOUNT
1	✓ 100	MS21075L06N NUT CTRL# : 2006E03344 LOT# : RK275 LOT QTY: 100 *** SHIPPED 1 CTN *** # 1=CTN 1# 6 OZ. FREIGHT ACCT# 151793240  TEL# 613-632-3336 DIMENSIONS: 9X9X8			EA	0	100	
Blf 706506		SHIPPED ON:08/09/06						
INVOICE#.....: 539983								
ORDER#.....: 706506								

MATERIAL TO BE RETURNED MUST HAVE PRIOR AUTHORIZATION BY M & M AEROSPACE

WE HEREBY CERTIFY THAT ALL PROVISIONS OF THE FAIR LABOR STANDARDS ACT ON JUNE 25, 1983, AS AMENDED, HAVE BEEN FULLY COMPLIED WITH IN THE MANUFACTURE, PRODUCTION OR PURCHASE OF GOODS LISTED HEREON.

ALL ITEMS ARE SUBJECT TO A 100% RESTOCKING CHARGE. ALL PAST DUE ACCOUNTS SHALL BEAR INTEREST AT THE RATE OF 1 1/2% MONTH (18% PER ANNUM).

MATERIAL CERTIFICATION

M & M AEROSPACE HARDWARE, INC. ("M & M AEROSPACE") WARRANTS THAT THE ITEMS SUBJECT OF THIS INVOICE WILL BE FREE FROM DEFECTS OF MATERIAL OR WORKMANSHIP AND AS SET FORTH ON THE MATERIAL CERTIFICATION FORM ACCOMPANYING THE ITEMS SUBJECT OF THIS INVOICE, ARE IN CONFORMITY WITH ALL CURRENT REQUIREMENTS AND THE SPECIFICATIONS OF THE RESPECTIVE MANUFACTURERS. M & M AEROSPACE DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND OF FITNESS FOR A PARTICULAR PURPOSE. THE LIABILITY OF M & M AEROSPACE IS EXPRESSLY LIMITED EXCLUSIVELY TO REPLACEMENT OF AN ITEM WHICH IS REJECTED BECAUSE OF A DEFECT IN MATERIAL OR WORKMANSHIP SUCH REPLACEMENT SHALL CONSTITUTE SATISFACTION OF ALL LIABILITY M & M MAY HAVE IN CONNECTION WITH SUCH ITEM, WHETHER LIABILITY IS BASED UPON CONTRACT RIGHTS, NEGLIGENCE, OR OTHERWISE, AND IN NO EVENT SHALL M & M AEROSPACE BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES. FURTHER, M & M AEROSPACE MUST BE NOTIFIED OF A REJECTION OF AN ITEM WITHIN 30 DAYS AFTER RECEIPT BY THE CUSTOMER.



PACKING SLIP

Larry Goul
Vice President of Quality Assurance

BY RECEIVING DELIVERY OF THE GOODS COVERED BY THIS INVOICE, BUYER EXPRESSLY ASSENTS TO THE TERMS AND CONDITIONS SET FORTH ON THE REVERSE HEREOF



MS21075L06 m101807

CERTIFICATE OF TEST

WE HEREBY CERTIFY THAT ALL MATERIALS USED IN THE MANUFACTURE OF PARTS COVERED BY THIS REPORT CONFORM TO THE MATERIAL SPECIFICATIONS CALLED FOR BY THE PURCHASE ORDER. WE FURTHER CERTIFY THAT THE PARTS ARE MANUFACTURED IN ACCORDANCE WITH APPLICABLE DRAWINGS OR SPECIFICATIONS CURRENT ON THE DATE OF MANUFACTURE. TEST REPORTS COVERING MATERIALS IN THESE PARTS AND INDICATING CONFORMANCE WITH APPLICABLE SPECIFICATIONS, ARE ON FILE AND SUBJECT TO EXAMINATION. PARTS AS SHIPPED HAVE NEVER BEEN IN CONTACT WITH MERCURY. THIS REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY. PARTS MANUFACTURED IN U.S.A.

Deelfina Martinez

SIGNATURE

QUALITY ASSURANCE REPRESENTATIVE

P.O.

0A3457

PART NO.

MS21075L06N

QUANTITY ORDERED

29,280

DATE CERT ORDERED

5-11-06

CUSTOMER

M3M Aerospace

LOT NO,

RK275

DESCRIPTION

Assembly

PROCUREMENT SPEC

NASmd5027

ALSO CERTIFIED TO

NAS1068A06L

Rev. 13



SHIP TO

SHIP TO

SHIPTO

INSPECT IMMEDIATELY

THE
yo
fe
yo
oro

SIGNATURE - MERCHAND

MS20426AD3-4 m 15786